

Work Order ID 61123

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Friday, August 06, 2010 2:19:32 PM

ASAP

Item ID: D4148-1**Accept****Setup****Start****Revision ID:****Stop****Item Name:** Crosstube Lug Plate, Fwd**Start Date:** 8/9/2010 **Start Qty:** 2.00**Cust Item ID:****Required Date:** 8/10/2010 **Req'd Qty:** 2.00**Customer:****Reference:****Approvals:** Process Plan: MFDate: 10-8-6

Tooling:

Date:

Run**Start**

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--	----------------------------------	------------------------------	----------------	---------------	----------------------	-----------------------	-----------------------	--------------------------	------------------------

Draw Nbr	Revision Nbr
D4148	B

100

 Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4148

Prog Rev: RDwg Rev: S

Deburr as required

B10-8-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC**Memo**

0.00

Quality Control

B10-8-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4148-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop



Start Date: 8/9/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/10/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

(+2)

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Siolos Log



QC

Memo

0.00

150

Identify as per dwg & Stock Location: RUS5

0.00

MF 10-8-9



Packaging

Memo

0.00

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/08/09 J

01 08 Aug MF
10-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61123



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 8/9/2010

Required Date: 8/10/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	90.4082	0.3607	0.759368		RB 10-8-4	

Location	Loc Qty	Loc Code
MAT	90.4082	
114488	0.6359	
114799	89.7723	114799

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 61123

Description: CROSSTUBE LUG PLATE FWD

Part Number: 4148-1

Inspection Dwg:D4148-1 Rev: B

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FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✗		V (BO)	
Ø .257	+ .006 - .001	.259	✗		V	
Ø .191	+ .005 - .001	.193	✗		V	
Ø .38	+ .006 - .001	.379	✗		V	
2.47	TL .30	2.463	✗		V	
.82	TL .30	.821	✗		V	
3.57	TL .030	3.573	✗		V	
1.23	TL .030	1.232	✗		V	
.90	TL .030	.902	✗		V	
.310 .370	TL .010	.313	✗		V	
.750	TL .010	.752	✗		V	
1.98	TL .030	1.981	✗		V	
1.84	TL .030	1.836	✗		V	
.92	TL .030	.917	✗		V	
.375	TL .010	.377	✗		V	
4.730	TL .010	4.733	✗		V	
5.300	TL .030	5.301	✗		V	
1.10	TL .030	1.107	✗		V	
2.284	TL .010	2.283	✗		V	
.625	TL .010	.629	✗		V	
1.000	TL .010	1.002	✗		V	
.500	TL .010	.501	✗		V	
.750	TL .010	.754	✗		V	

Measured by: IB

Audited by: S

Prototype Approval: N/A

Date: 10-8-9

Date: 10/08/09

Date: N/A

Rev	Date	Change
A		New Issue

Revised by	Approved
KJ/JLM	

DART AEROSPACE LTD	Work Order:	61123
Description: CLESS TUBE LUG PLATE FWD	Part Number:	D4148-1
Inspection Dwg: D4148-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

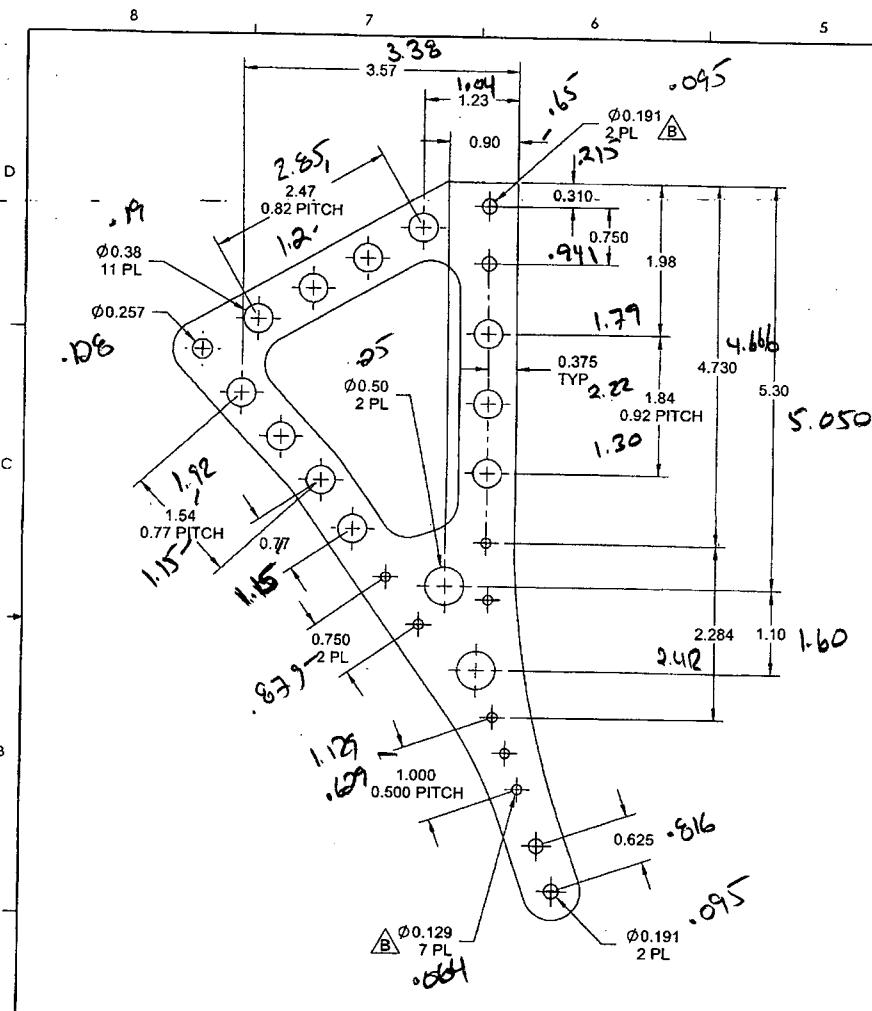
X First Article Prototype

Measured by:	PB
Date:	10-9-8

Audited by:	S
Date:	10/02/05

Prototype Approval:	N/A
Date:	N/A

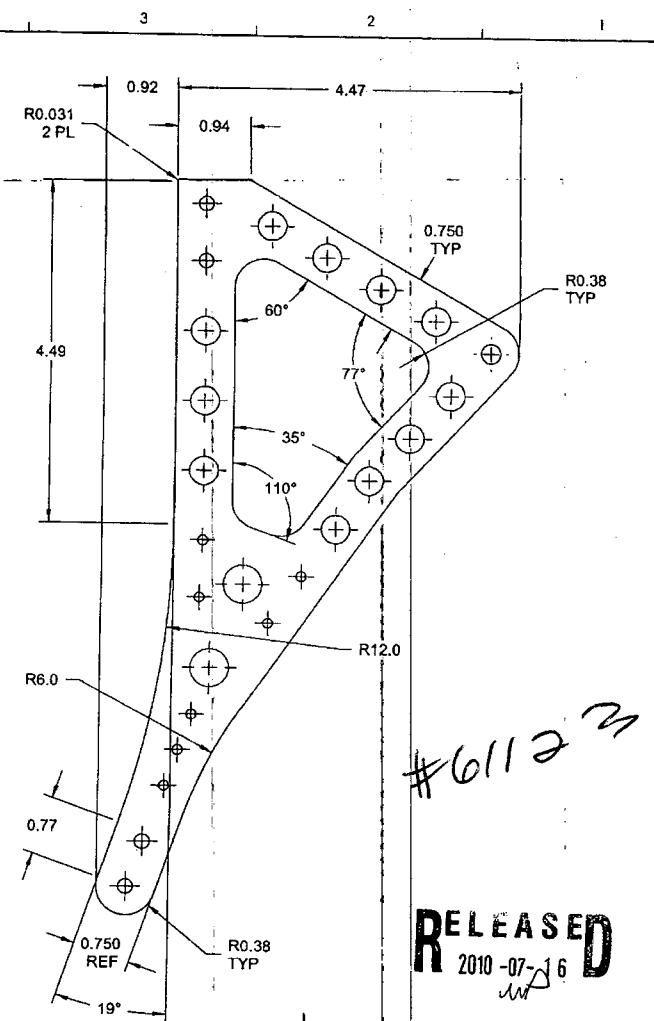
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC MS304S11GA OR MS303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.48 lbs



DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE
DATE	10.07.05	SCALE
		NTS

FWD X-TUBE LUG ASSY

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